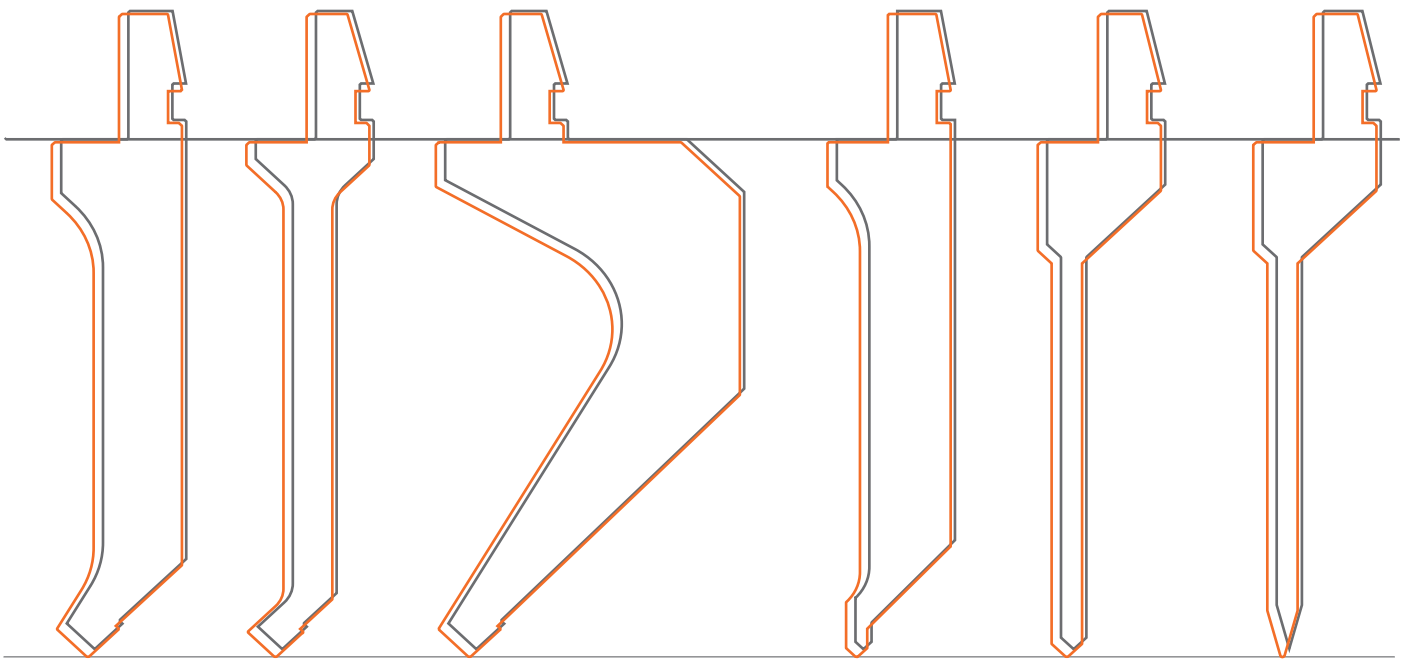


# PRESS BRAKE TOOLS

SPECIAL BENDING TOOLS

PRODUCT CATALOG

**AMADA TYPE**



# INDEX

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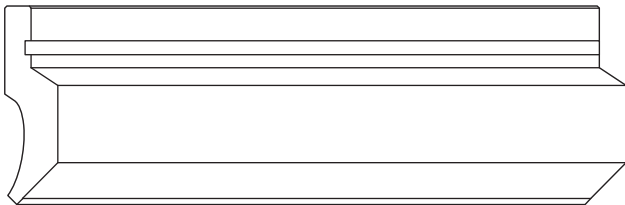
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\*Mentioned tonnage in the table is for standard type.

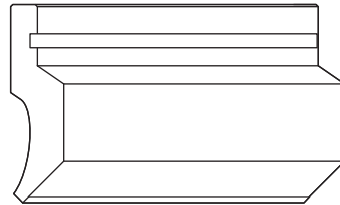
# INFORMATION

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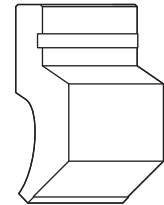
## ■ TOOL LENGTH



Type L 835 mm

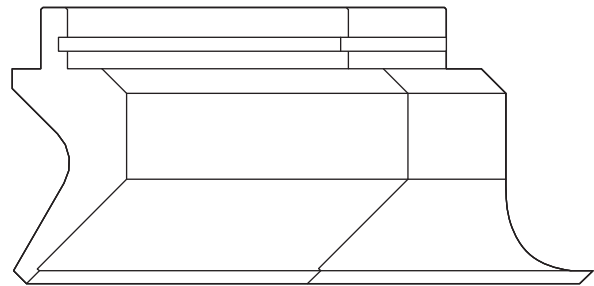
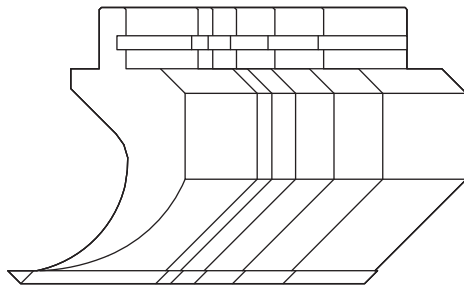


Type M 510 mm



Type SS 200 mm

## ■ SECTIONING



### ■ SECTIONING (PUNCH)

SECTIONING A (Total 370mm) 10 ▪ 10 ▪ 15 ▪ 20 ▪ 25 ▪ 40 ▪ 50 ▪ 100 ▪ 100

SECTIONING B (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 100 ▪ 100 ▪ 165 ▪ 300

EARS 200mm 100 (Right) ▪ 100 (Left)

### ■ SECTIONING (DIE)

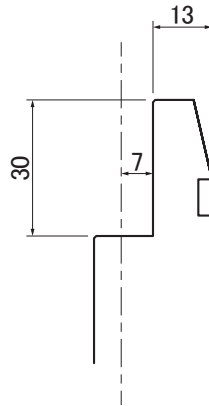
SECTIONING A (Total 370mm) 10 ▪ 10 ▪ 15 ▪ 20 ▪ 25 ▪ 40 ▪ 50 ▪ 100 ▪ 100

SECTIONING B (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 100 ▪ 100 ▪ 165 ▪ 300

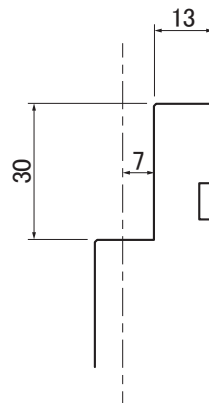
# CLAMP TYPE

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## ■ OT-TYPE (One Touch)

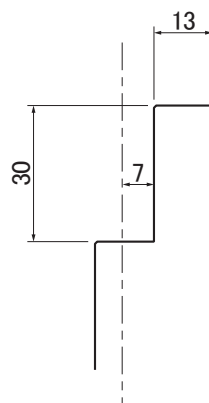


## ■ A9-TYPE (Safety Groove)



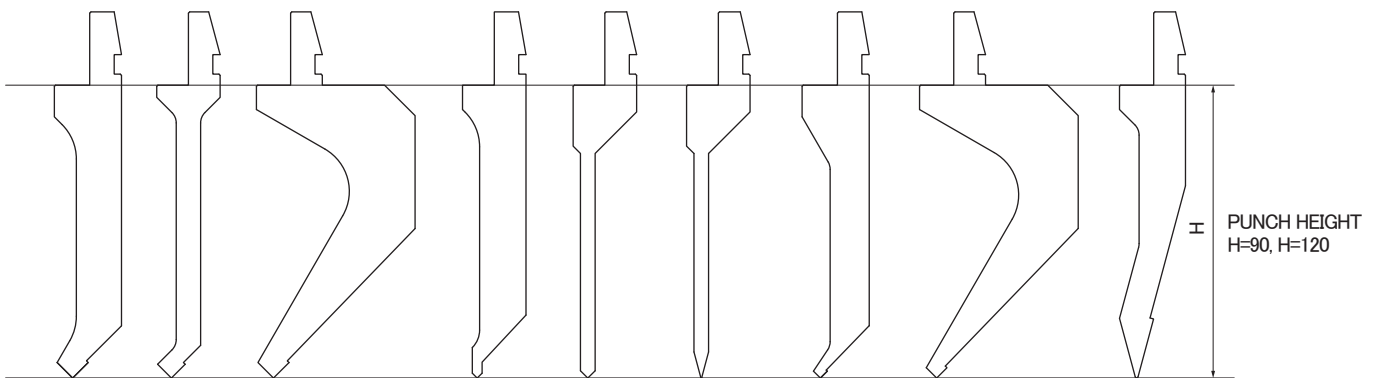
## ■ STANDARD-TYPE

Recommend other type



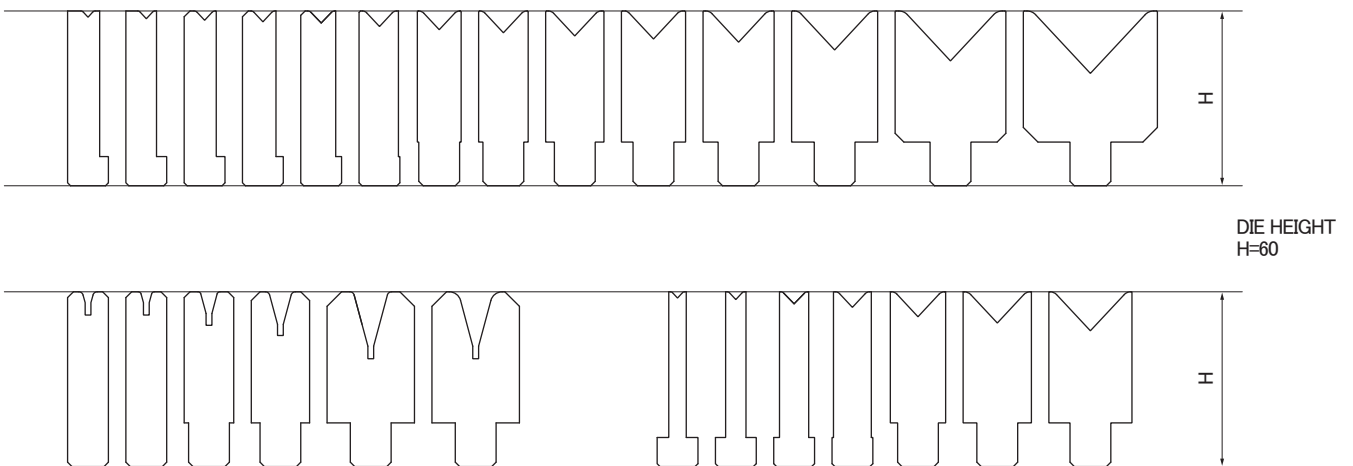
# UNIFIED HEIGHT SYSTEM

## ■ PUNCH



※H=90 does not include Burring Punch

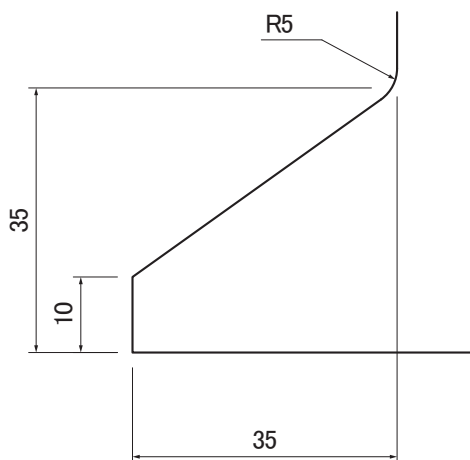
## ■ DIE



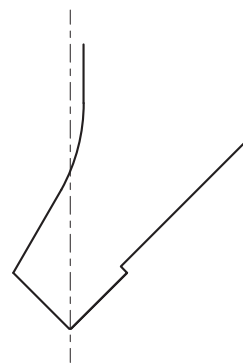
# STANDARD 1

Material: **SCM440**      Hardness: **HRC47 ± 3**  
 L: 835mm   M: 510mm   SS: 200mm  
 Sectioning A: 370mm   B: 800mm   Ears: 200mm

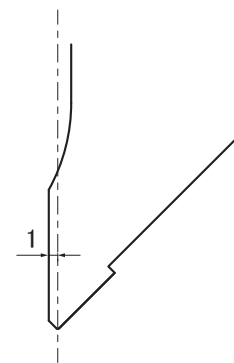
Type	H	$\alpha$	R	k	Max	Product No		
	(mm)	Angle	(mm)	(mm)	(ton/m)			
STANDARD1	90	86	0.2	9	100	ST9-09-8602		
			0.6			ST9-09-8606		
			1.5			ST9-09-8615		
			2.3			ST9-09-8623		
			3.0			ST9-09-8630		
			88			0.2	ST9-09-8802	
		0.6				ST9-09-8806		
		3.0				ST9-09-8830		
		120	86			0.2	ST9-09-9002	
	0.6					ST9-12-8602		
	1.5					ST9-12-8606		
	2.3					ST9-12-8615		
	3.0					ST9-12-8623		
	3.0					ST9-12-8630		
	88		0.2			ST9-12-8802		
			0.6			ST9-12-8806		
			3.0			ST9-12-8830		
			90			0.2	ST9-12-9002	
						86	0.2	STT-12-8602
							0.6	STT-12-8606
	88	0.2	STT-12-8802					
0.6		STT-12-8806						



45ton/m  
T-TYPE 40ton/m



STANDARD1



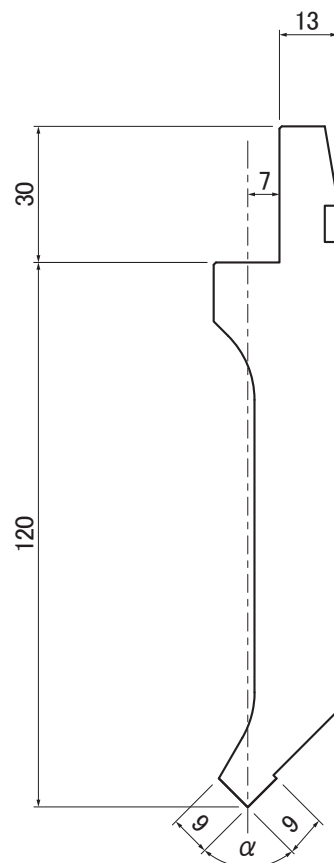
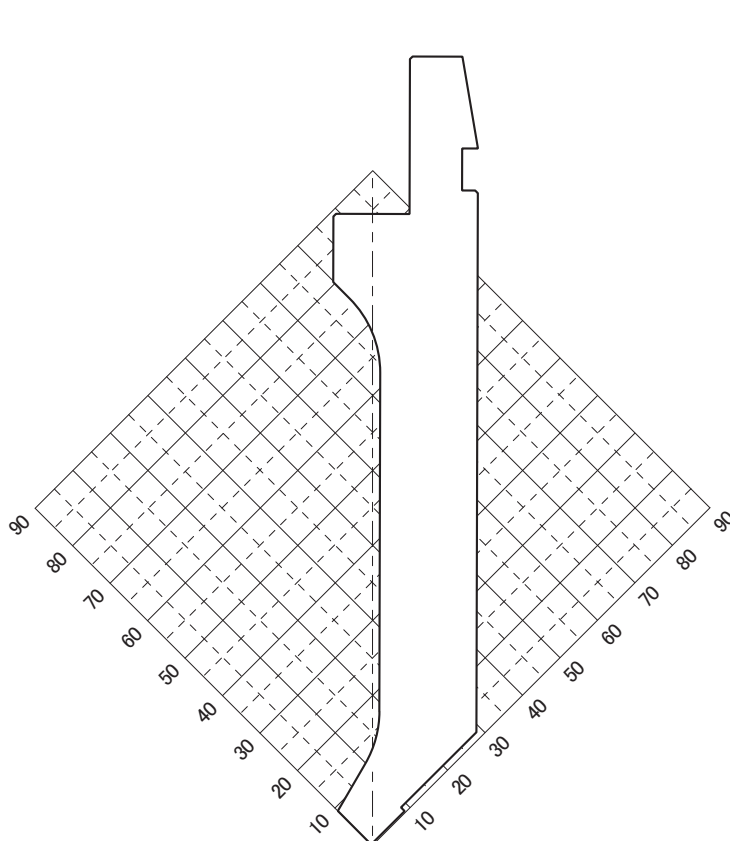
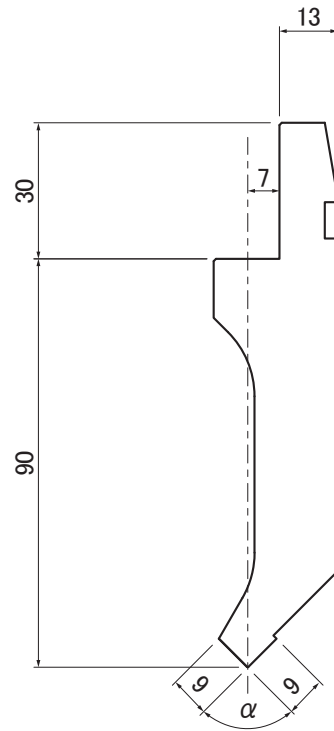
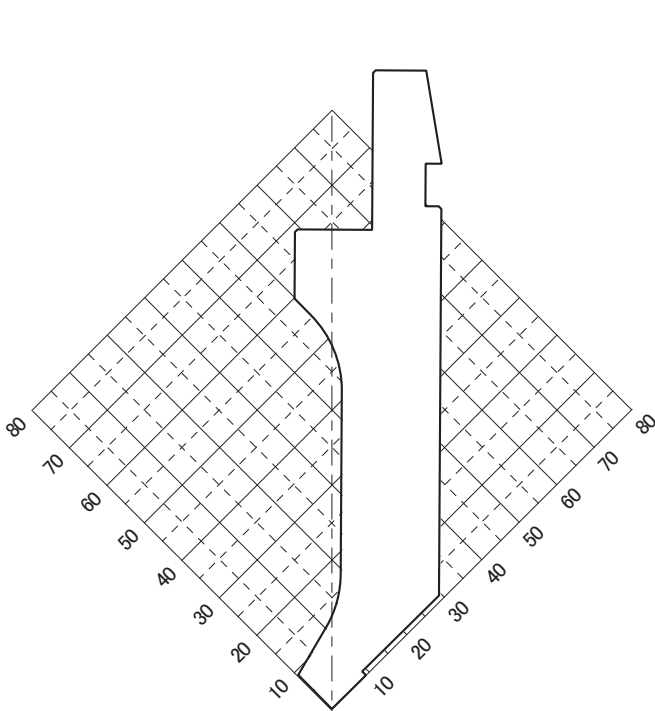
STANDARD1  
T-TYPE

# STANDARD 1

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



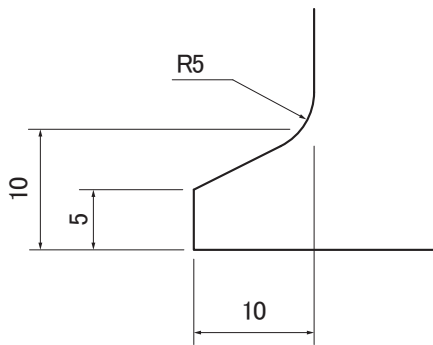
# STANDARD 2

Material: **SCM440**      Hardness: **HRC47 ± 3**

L: 835mm   M: 510mm   S: 200mm

Sectioning A: 370mm   B: 800mm   Ears: 200mm

Type	H	$\alpha$	R	k	Max	Product No
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD2	90	86	0.2	4	20	ST4-09-8602
			0.6			ST4-09-8606
		88	0.2			ST4-09-8802
			0.6			ST4-09-8806
		90	0.2			ST4-09-9002
		120	86			0.2
	0.6					ST4-12-8606
	88		0.2			ST4-12-8802
			0.6			ST4-12-8806
	90		0.2			ST4-12-9002

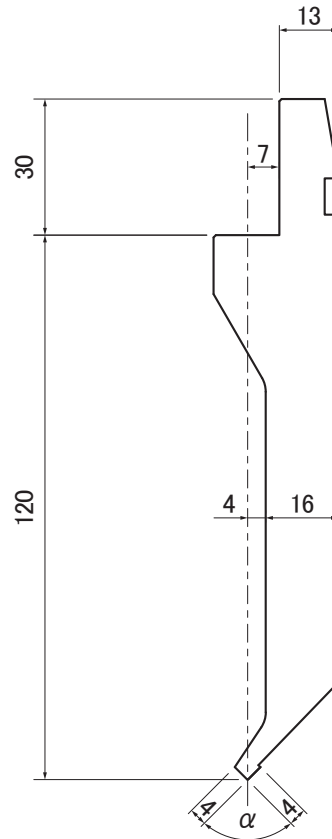
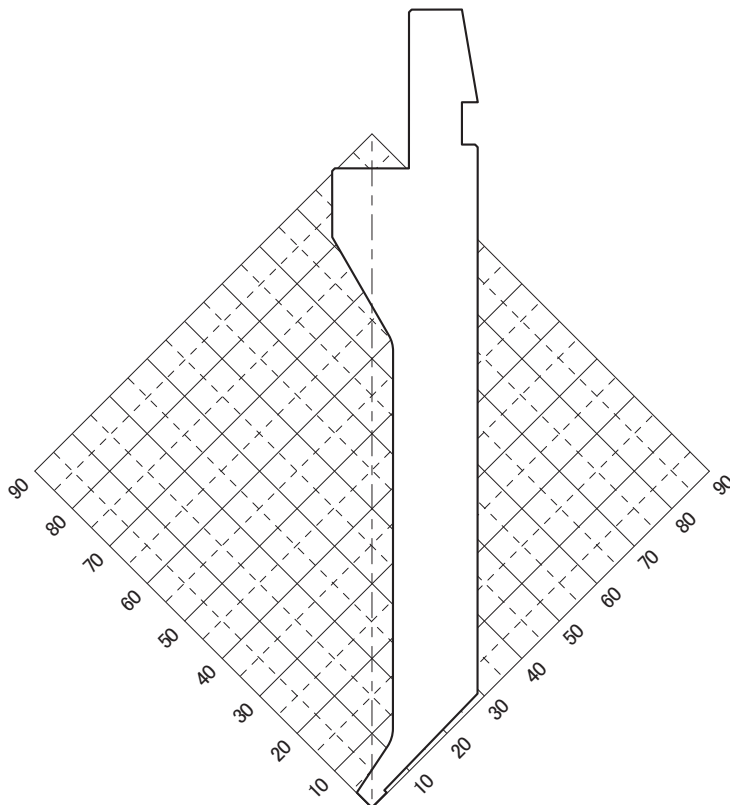
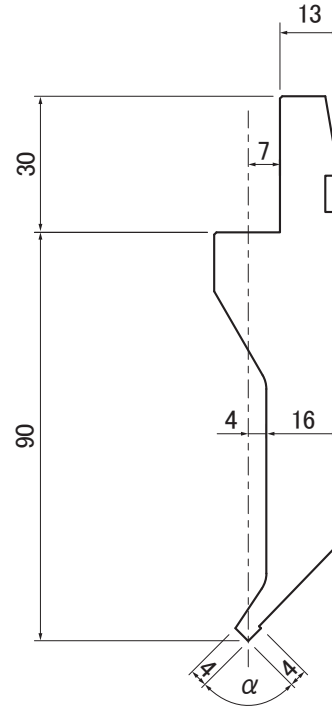
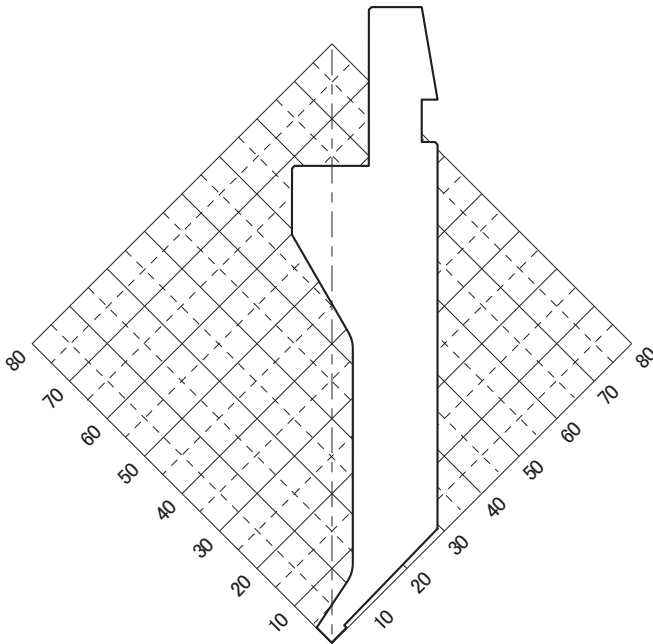


10ton/m



# STANDARD 2

Material: **SCM440**      Hardness: **HRC47 ± 3**  
 L: 835mm    M: 510mm    SS: 200mm  
 Sectioning A: 370mm    B: 800mm    Ears: 200mm



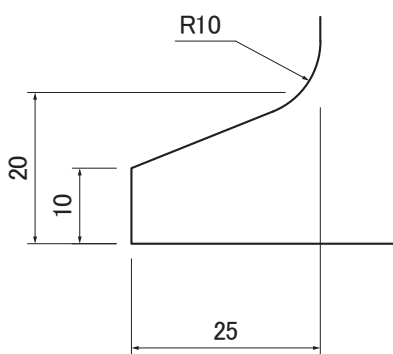
# SASH

Material: **SCM440** Hardness: **HRC47 ± 3**

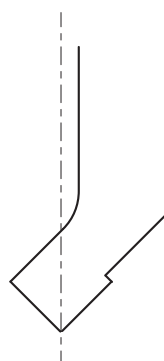
L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

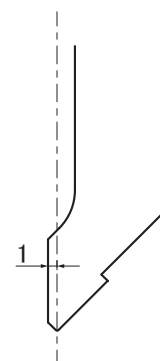
Type	H (mm)	$\alpha$ Angle	R (mm)	k (mm)	Max (ton/m)	Product No		
	SASH	90	86	0.2	8		30	SS8-09-8602
0.6				SS8-09-8606				
3.0				SS8-09-8630				
88			0.2	SS8-09-8802				
			0.6	SS8-09-8806				
			3.0	SS8-09-8830				
90			0.2	SS8-09-9002				
			120	86		0.2		SS8-12-8602
						0.6		SS8-12-8606
3.0		SS8-12-8630						
88		0.2		SS8-12-8802				
		0.6		SS8-12-8806				
		3.0		SS8-12-8830				
90		0.2	SS8-12-9002					
		SASH T-TYPE	86	0.2		SST-12-8602		
	0.6			SST-12-8606				
88	0.2		SST-12-8802					
	0.6	SST-12-8806						



15ton/m  
T-Type 10ton/m



SASH



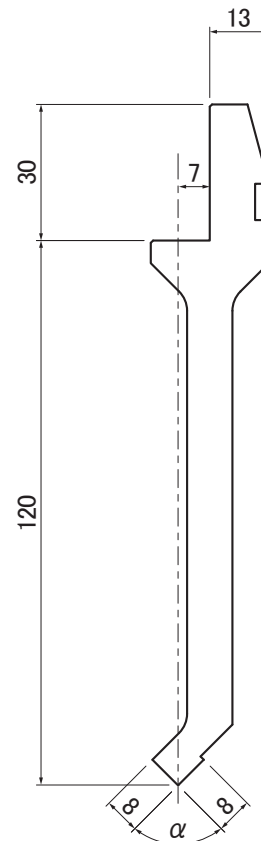
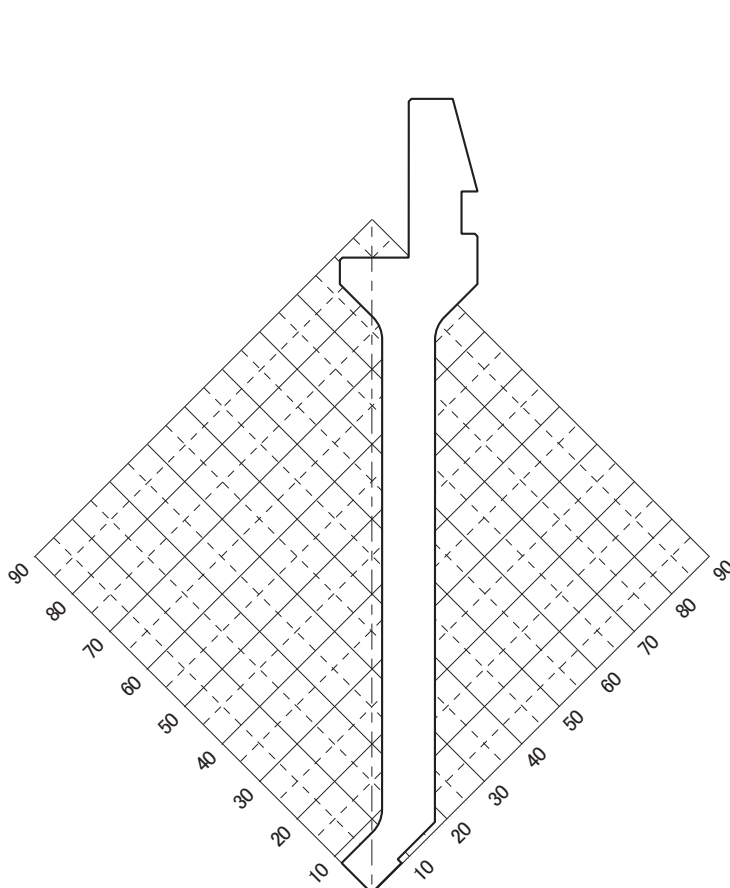
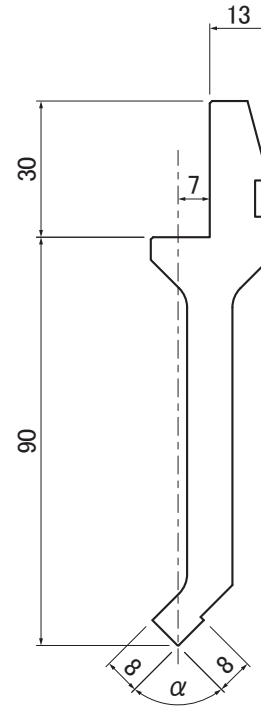
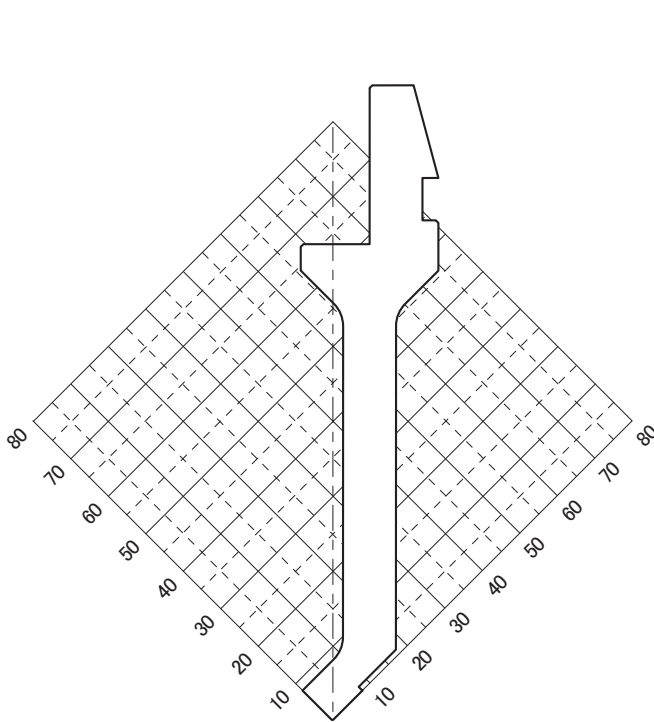
SASH  
T-TYPE

# SASH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

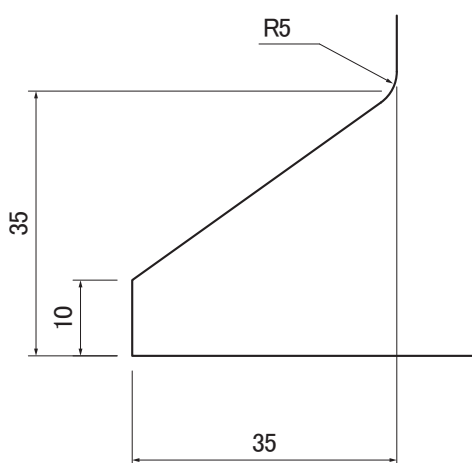
Sectioning A: 370mm B: 800mm Ears: 200mm



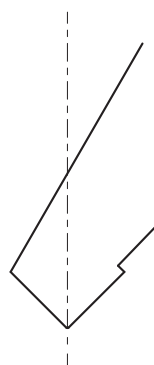
# GOOSENECK 1

Material: **SCM440**      Hardness: **HRC47 ± 3**  
 L: 835mm   M: 510mm   SS: 200mm  
 Sectioning A: 370mm   B: 800mm   Ears: 200mm

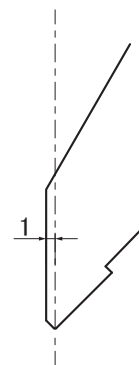
Type	H (mm)	$\alpha$ Angle	R (mm)	k (mm)	Max (ton/m)	Product No	
	GOOSENECK1	90	86	0.2	9		50
0.6				GN9-09-8606			
3.0				GN9-09-8630			
88			0.2	GN9-09-8802			
			0.6	GN9-09-8806			
			0.2	GN9-09-9002			
120			86	0.2		GN9-12-8602	
				0.6		GN9-12-8606	
				1.5		GN9-12-8615	
		2.3		GN9-12-8623			
		3.0		GN9-12-8630			
		0.2		GN9-12-8802			
		88	0.6	GN9-12-8806			
			3.0	GN9-12-8830			
			0.2	GN9-12-9002			
GOOSENECK1 T-TYPE		86	0.2	GNT-12-8602			
			0.6	GNT-12-8606			
			0.2	GNT-12-8802			
	88	0.6	GNT-12-8806				
		0.2	GNT-12-8802				
		0.6	GNT-12-8806				



45ton/m  
T-TYPE 15ton/m



GOOSENECK1



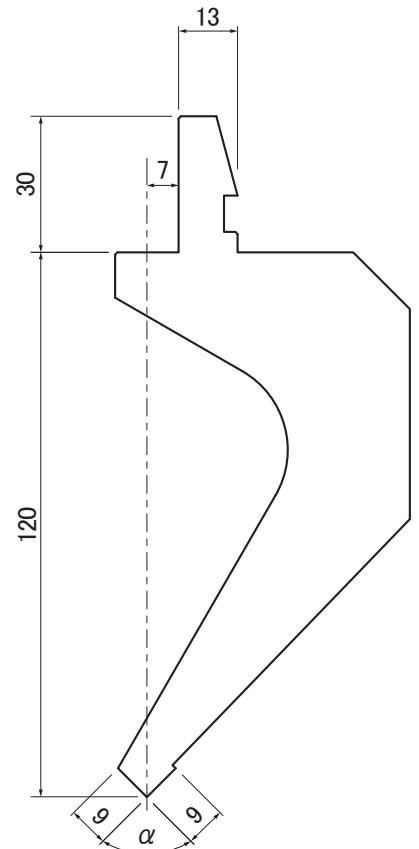
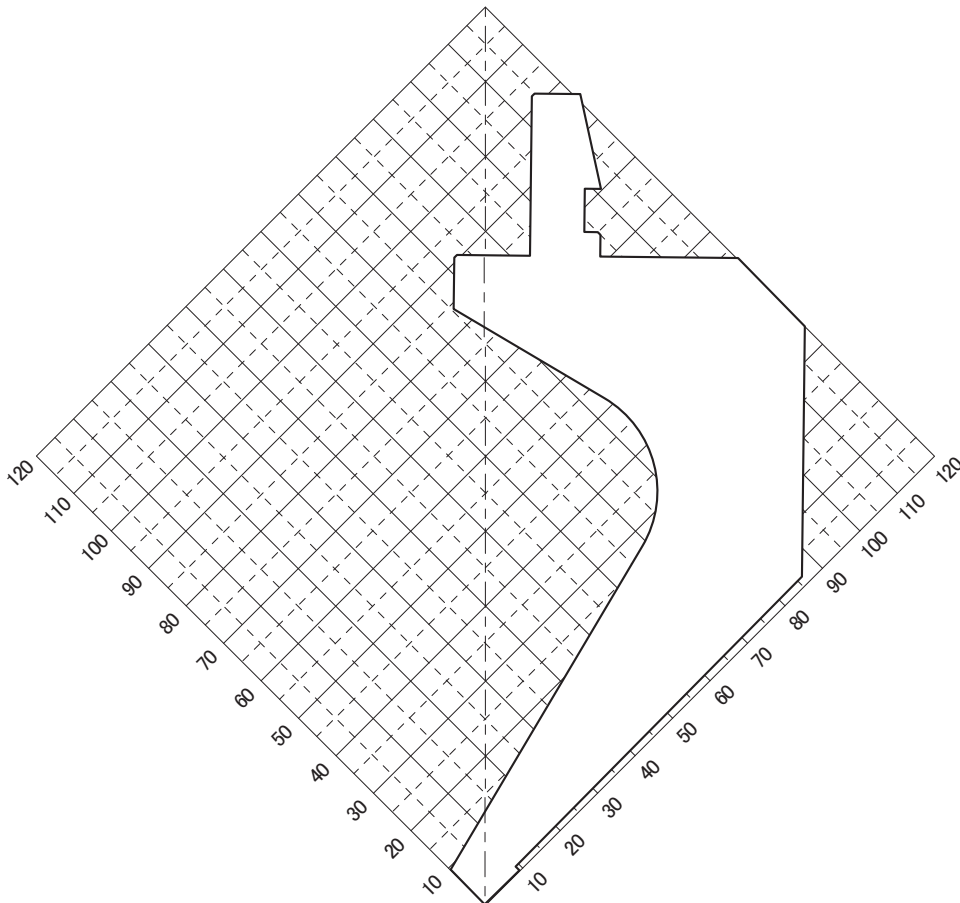
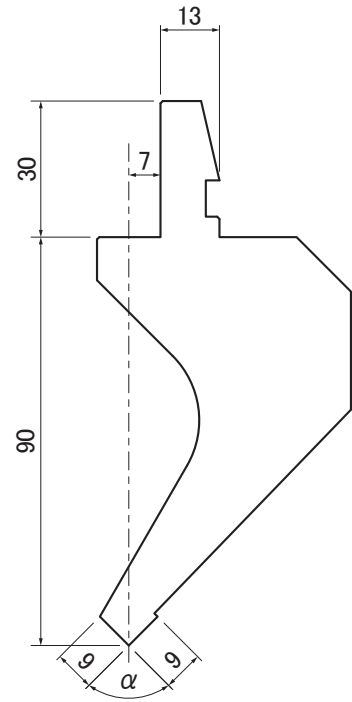
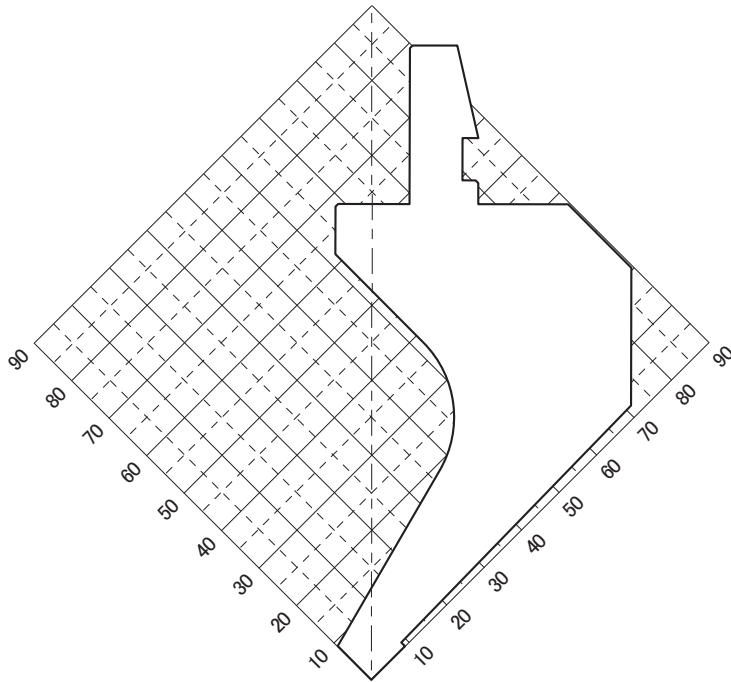
GOOSENECK1  
T-TYPE

# GOOSENECK 1

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

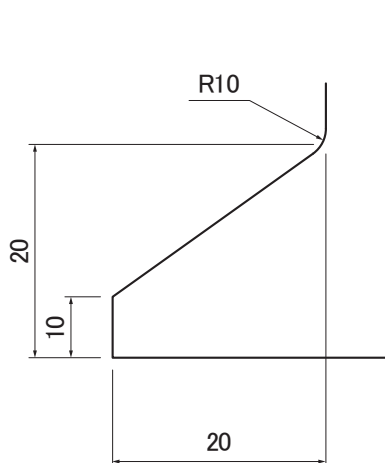
Sectioning A: 370mm B: 800mm Ears: 200mm



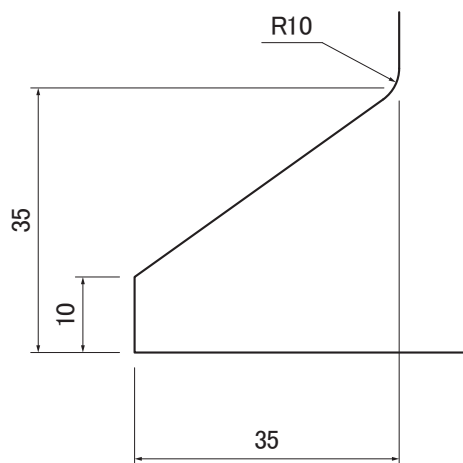
# GOOSENECK 2

Material: **SCM440** Hardness: **HRC47 ± 3**  
 L: 835mm M: 510mm SS: 200mm  
 Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H (mm)	$\alpha$ Angle	R (mm)	k (mm)	Max (ton/m)	Product No
	GOOSENECK 2	90	86	0.2	6	
0.6				GN6-09-8606		
3.0				GN6-09-8630		
88			0.2	GN6-09-8802		
			0.6	GN6-09-8806		
			0.2	GN6-09-9002		
120		86	0.2	35	GN6-12-8602	
			0.6		GN6-12-8606	
			3.0		GN6-12-8630	
		88	0.2		GN6-12-8802	
			0.6		GN6-12-8806	
			0.2		GN6-12-9002	



30ton/m  
H90



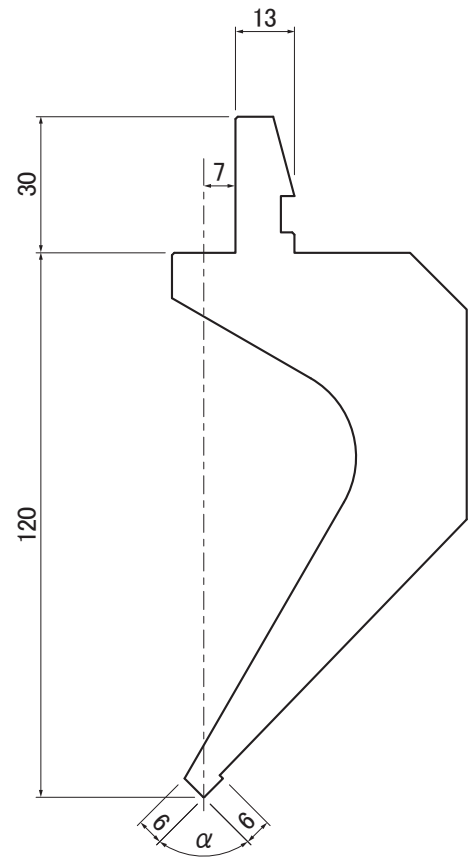
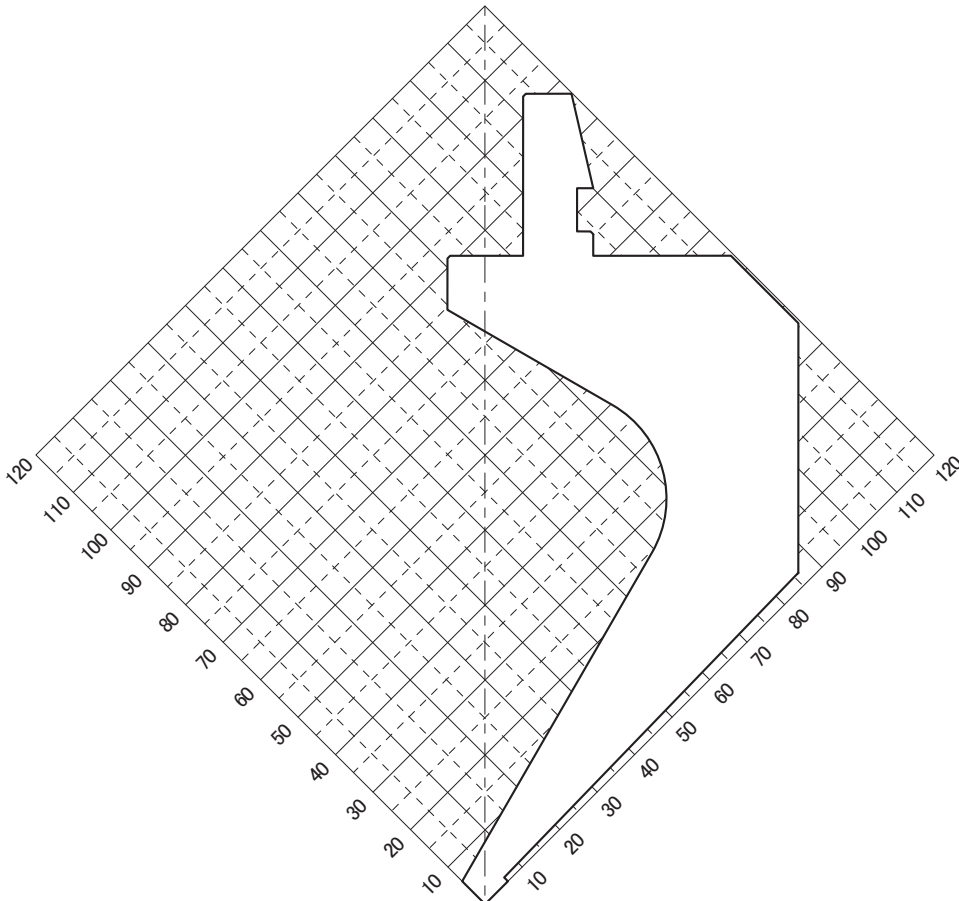
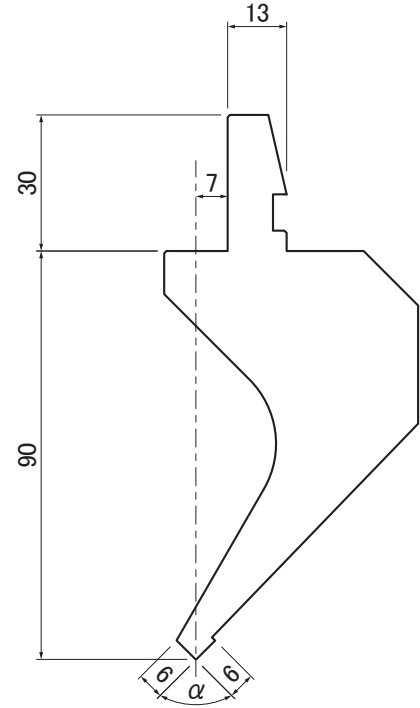
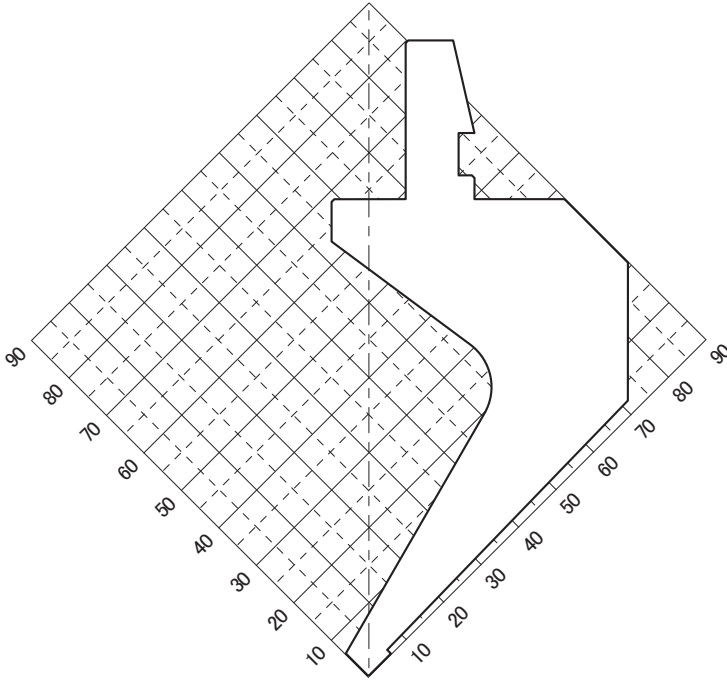
15ton/m  
H120

# GOOSENECK 2

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



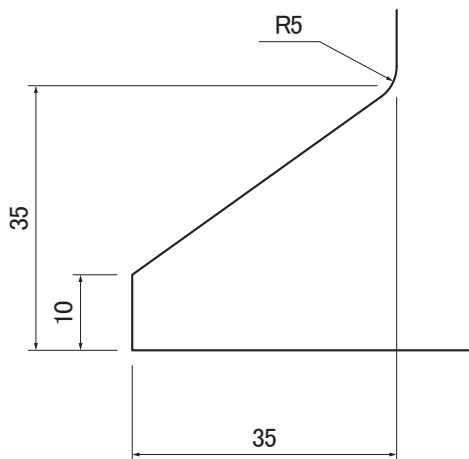
# BURRING

Material: **SCM440**      Hardness: **HRC47 ± 3**

L: 835mm    M: 510mm    SS: 200mm

Sectioning A: 370mm    B: 800mm    Ears: 200mm

Type	H	$\alpha$	R	Max	Product No
	(mm)	Angle	(mm)	(ton/m)	
BURRING	90	86	0.2	40	BR4-09-8602
			0.6		BR4-09-8606
		90	0.2		BR4-09-9002
			0.6		BR4-12-8602
	120	86	0.2		BR4-12-8606
			0.6		BR4-12-8606
		90	0.2		BR4-12-9002
			0.6		BR4-12-9002

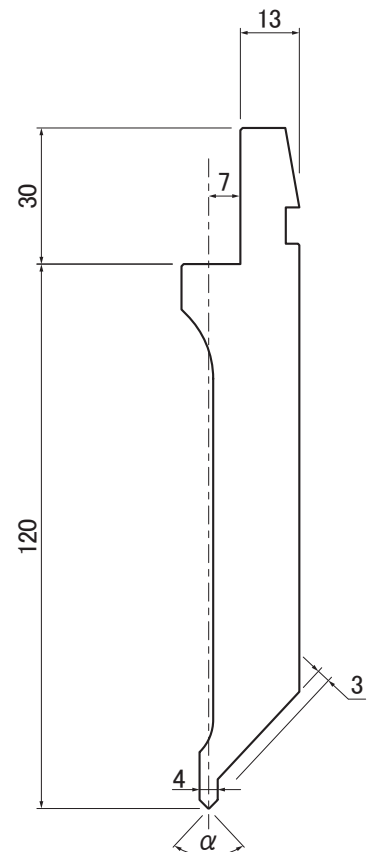
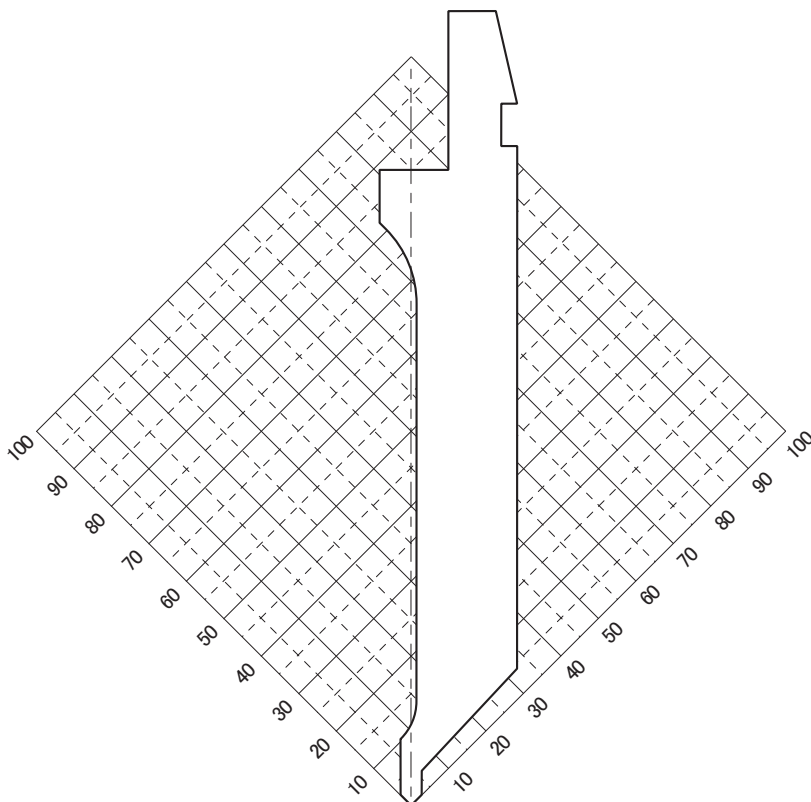
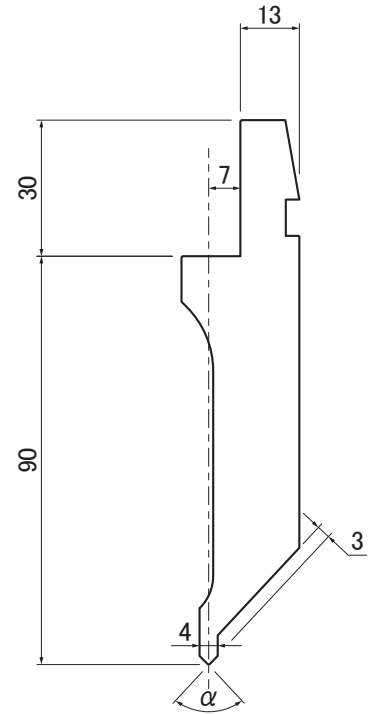
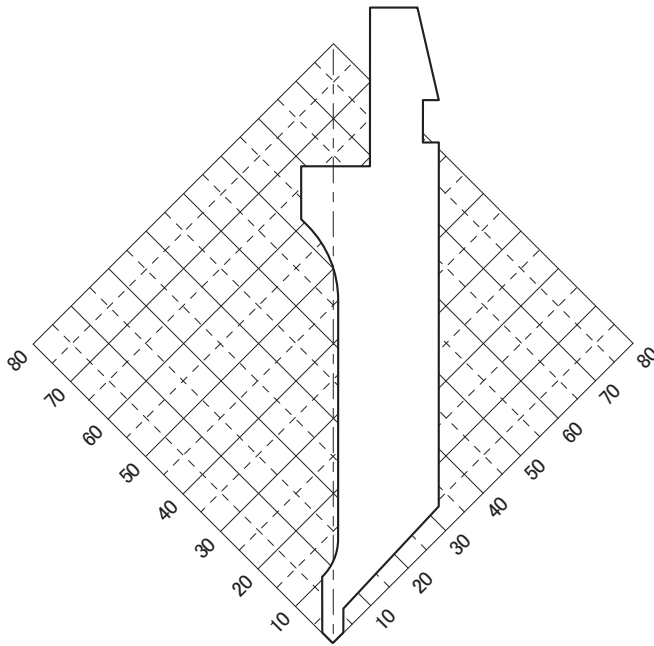


20ton/m



# BURRING

Material: **SCM440** Hardness: **HRC47 ± 3**  
 L: 835mm M: 510mm SS: 200mm  
 Sectioning A: 370mm B: 800mm Ears: 200mm



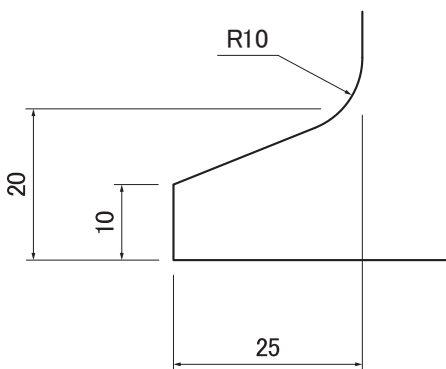
# STRAIGHT

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

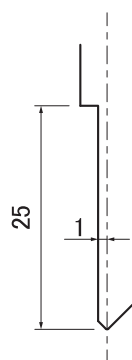
Type	H	$\alpha$	R	Max	Product No			
	(mm)	Angle	(mm)	(ton/m)				
STRAIGHT	90	86	0.2	50	STR-09-8602			
			0.6		STR-09-8606			
			3.0		STR-09-8630			
		88	0.2		STR-09-8802			
			0.6		STR-09-8806			
			3.0		STR-09-8830			
		90	0.2		STR-09-9002			
		120	86		0.2	50	STR-12-8602	
					0.6		STR-12-8606	
	3.0			STR-12-8630				
	88		0.2	STR-12-8802				
			0.6	STR-12-8806				
			3.0	STR-12-8830				
	90		0.2	STR-12-9002				
	STRAIGHT T-TYPE		86	86	0.2		40	STT-12-8602
					0.6			STT-12-8606
		0.2			STT-12-8802			
		88	0.6	STT-12-8806				
0.2			STT-12-8802					
0.6			STT-12-8806					



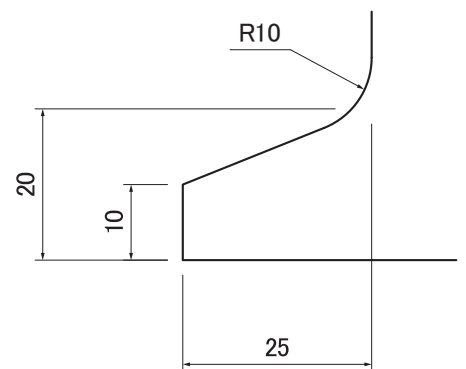
12ton/m  
STRAIGHT



STRAIGHT



STRAIGHT  
T-TYPE



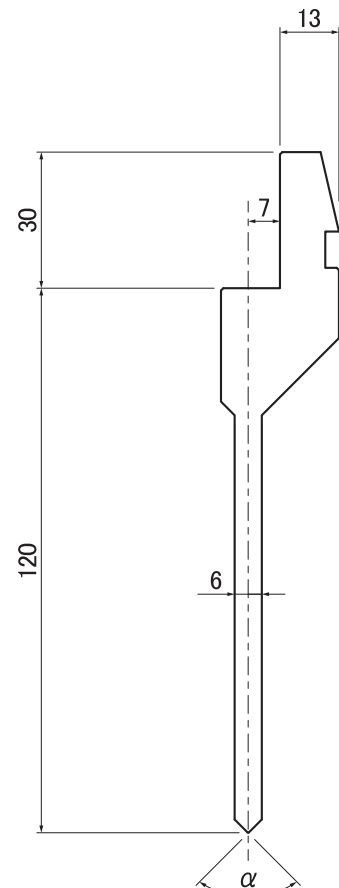
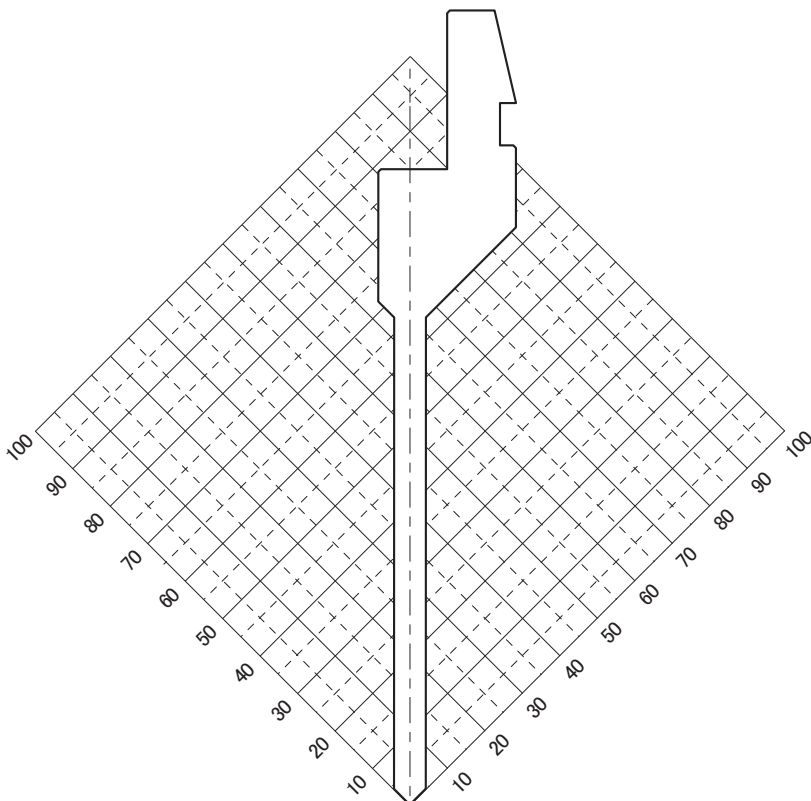
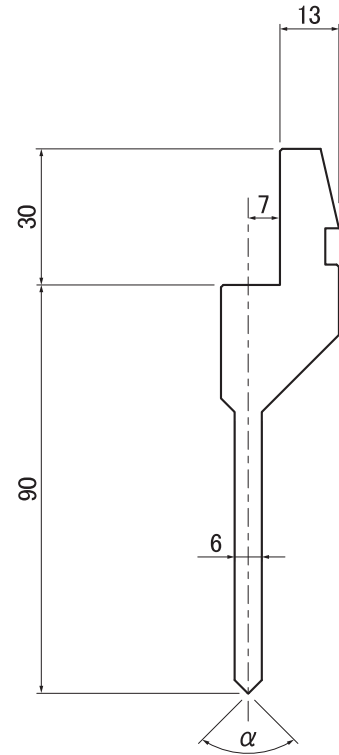
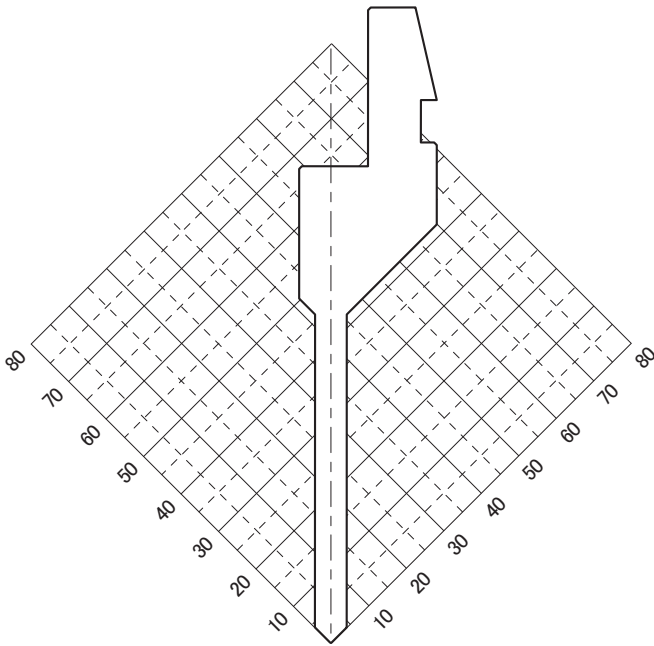
10ton/m  
STRAIGHT  
T-TYPE

# STRAIGHT

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



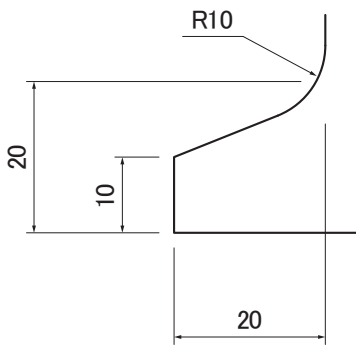
# ACUTE

Material: **SCM440**      Hardness: **HRC47 ± 3**

L: 835mm   M: 510mm   SS: 200mm

Sectioning A: 370mm   B: 800mm   Ears: 200mm

Type	H	$\alpha$	R	Max	Product No
	(mm)	Angle	(mm)	(ton/m)	
ACUTE	90	30	0.2	50	ACT-09-3002
			0.5		ACT-09-3005
			0.6		ACT-09-3006
	120		0.2		ACT-12-3002
			0.5		ACT-12-3005
			0.6		ACT-12-3006



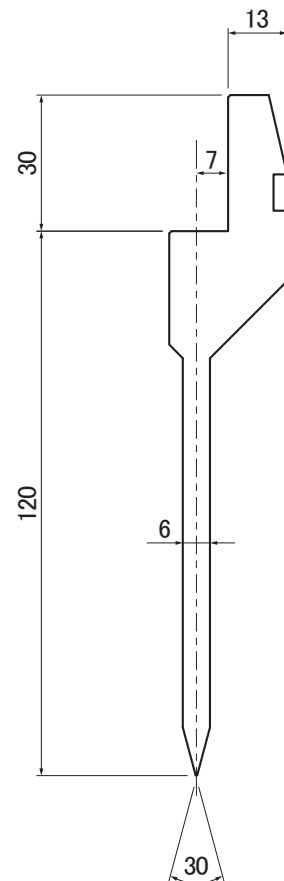
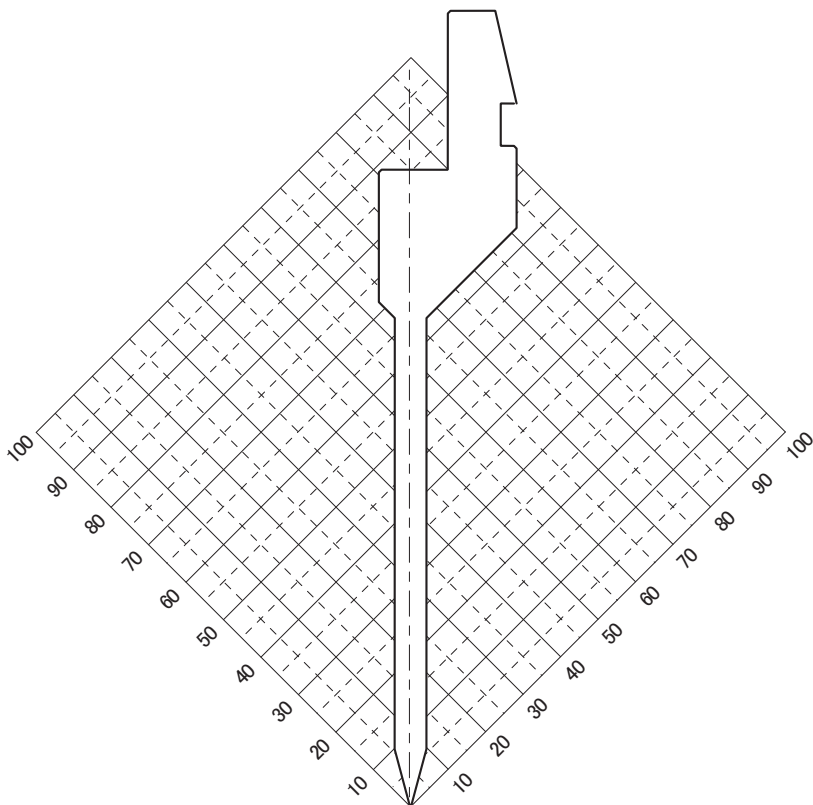
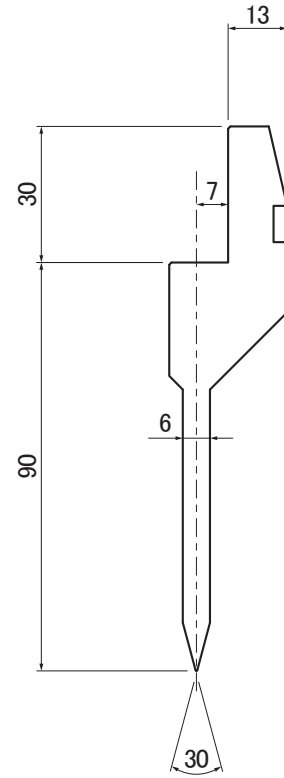
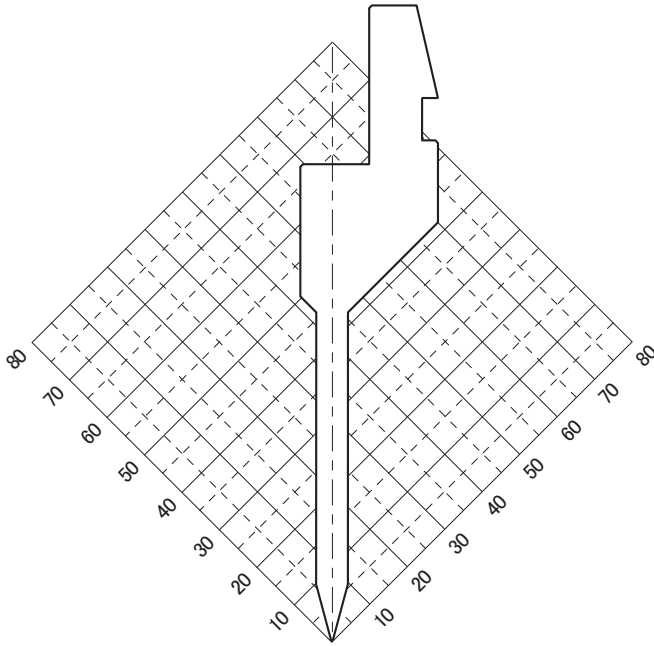
11ton/m

# ACUTE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



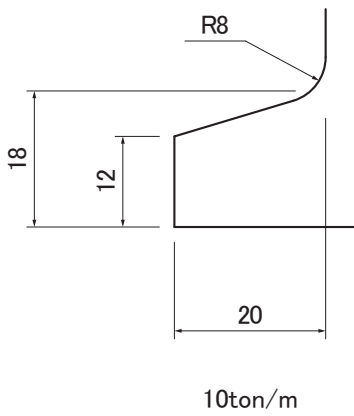
# HEMMING

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H	$\alpha$	R	Max	Product No
	(mm)	Angle	(mm)	(ton/m)	
HEMMING	90	30	0.6	40	HMG-09-3006
			0.65		HMG-09-3065
	120		0.6		HMG-12-3006
			0.65		HMG-12-3065

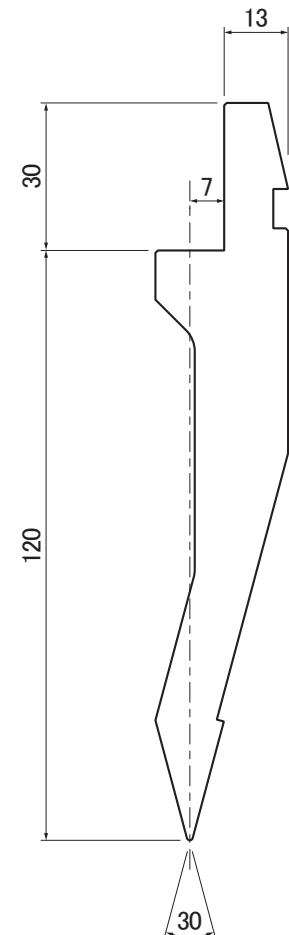
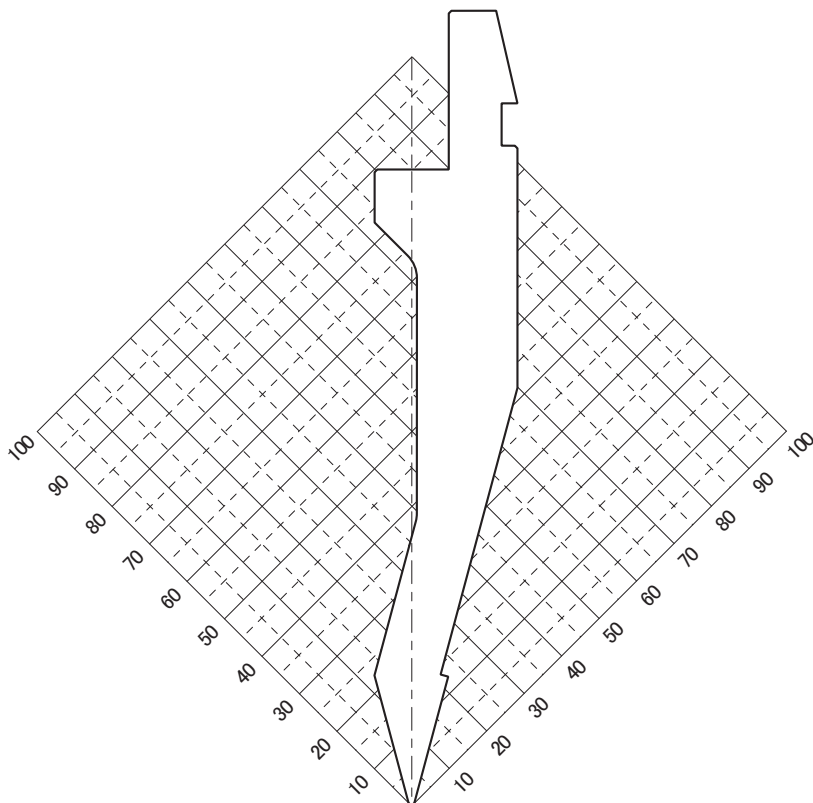
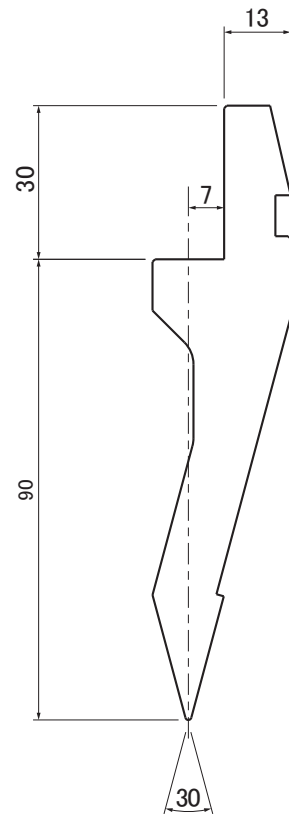
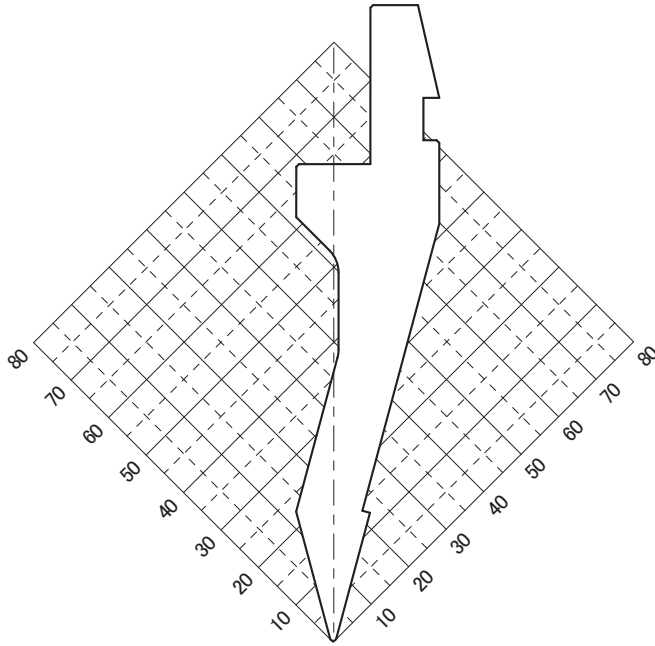


# HEMMING

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



# 86° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Series	V	$\alpha$	R	B	Max	Product No
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD	4	86	1.0	10.0	50	V004-86-S
	5			10.5		V005-86-S
	6		1.5	11.0	60	V006-86-S
	7			11.5	65	V007-86-S
	8			12.0	70	V008-86-S
	10		2.0	13.5	90	V010-86-S
	12		2.5	15.0		V012-86-S
	14			17.0	V014-86-S	
	16			20.0	V016-86-S	
	18			22.0	100	V018-86-S
	20		3.0	24.4	V020-86-S	
	25			29.5	V025-86-S	
R-TYPE	4	86	1.5	10.0	50	V004-86-R
	5			10.5		V005-86-R
	10		2.5	13.5	90	V010-86-R
	16		3.5	20.0	100	V016-86-R
	18			22.0		V018-86-R
	20		4.0	24.4	V020-86-R	
	25			29.5	V025-86-R	
T-TYPE	4	86	1.0	6.0	50	V004-86-T
	5			7.0		V005-86-T
	6		1.5	8.0	60	V006-86-T
	8			10.0	70	V008-86-T
	10		2.0	13.0	90	V010-86-T
	16		2.5	19.0	100	V016-86-T
	18			21.0		V018-86-T
	20		3.0	23.4	V020-86-T	
	25			28.5	V025-86-T	

\*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

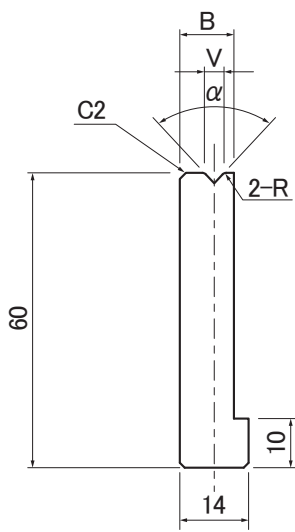
\*It does not have special relief on the bottom V for standard.

Please contact us if you require.

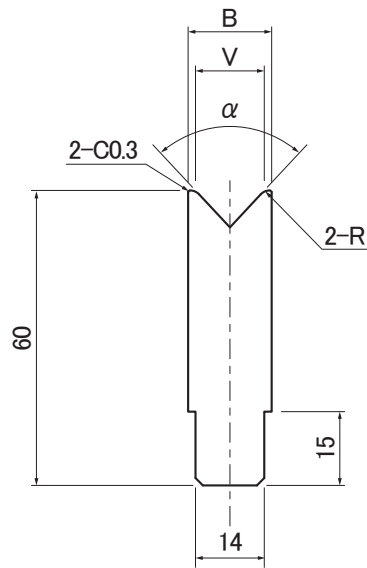


# 86° DIE

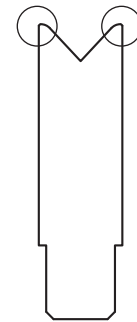
## ■ STANDARD



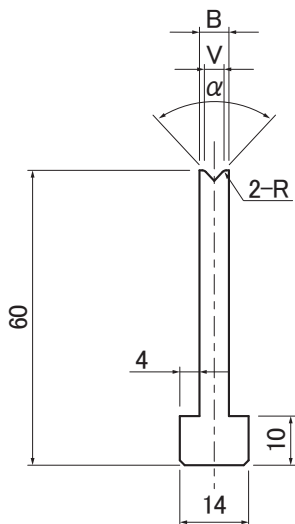
## ■ R-TYPE



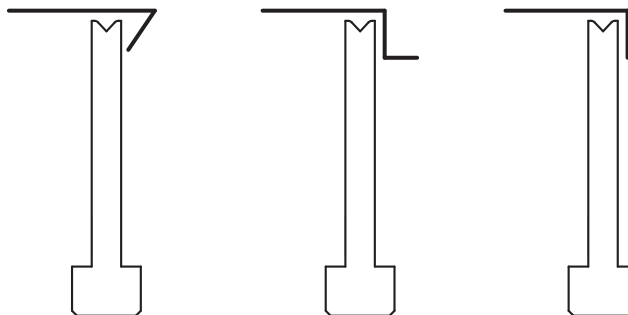
For reduce scratch



## ■ T-TYPE



For support short flange bending



# 88° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Series	V	$\alpha$	R	B	Max	Product No
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD	4	88	1.0	10.0	50	V004-88-S
	5			10.5		V005-88-S
	6		1.5	11.0	60	V006-88-S
	8			12.0	70	V008-88-S
	10		2.0	13.5	90	V010-88-S
	12		2.5	15.0		V012-88-S
	14			17.0	100	V014-88-S
	16			20.0		V016-88-S
	18			22.0	V018-88-S	
	20		3.0	24.4	100	V020-88-S
	25			29.5		V025-88-S
	R-TYPE		4	88	1.5	10.0
5		10.5	V005-88-R			
10		2.5	13.5		90	V010-88-R
16		3.5	20.0		100	V016-88-R
18			22.0			V018-88-R
20		4.0	24.4		100	V020-88-R
25			29.5			V025-88-R
T-TYPE	4	88	1.0	6.0	50	V004-88-T
	5			7.0		V005-88-T
	6		1.5	8.0	60	V006-88-T
	8			10.0	70	V008-88-T
	10		2.0	13.0	90	V010-88-T
	16		2.5	19.0	100	V016-88-T
	18			21.0		V018-88-T
	20		3.0	23.4	100	V020-88-T
	25			28.5		V025-88-T

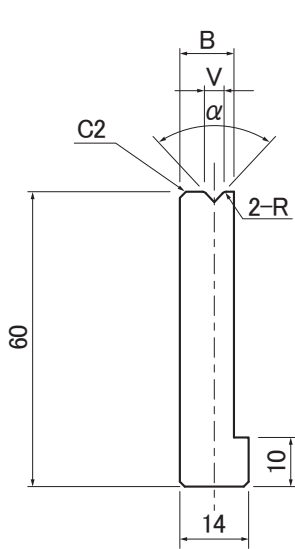
\*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

\*It does not have special relief on the bottom V for standard.

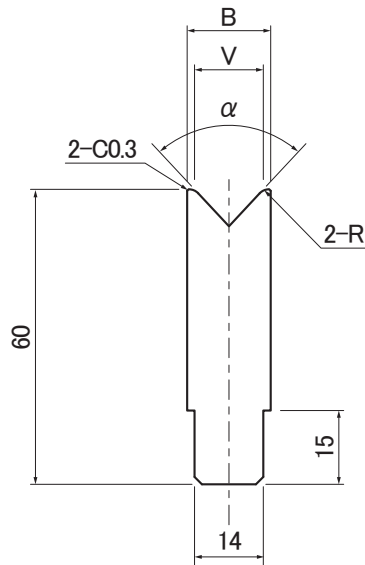
Please contact us if you require.

# 88° DIE

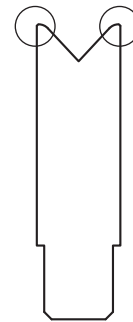
## ■ STANDARD



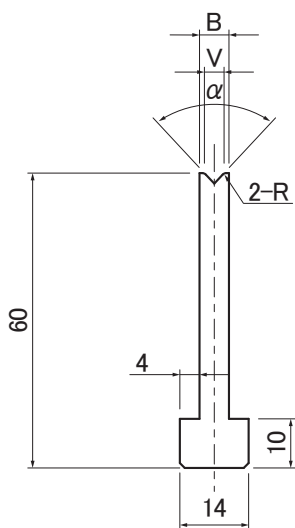
## ■ R-TYPE



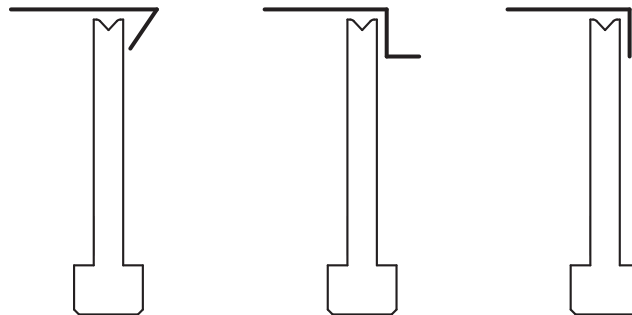
For reduce scratch



## ■ T-TYPE



For support short flange bending



# 90° DIE

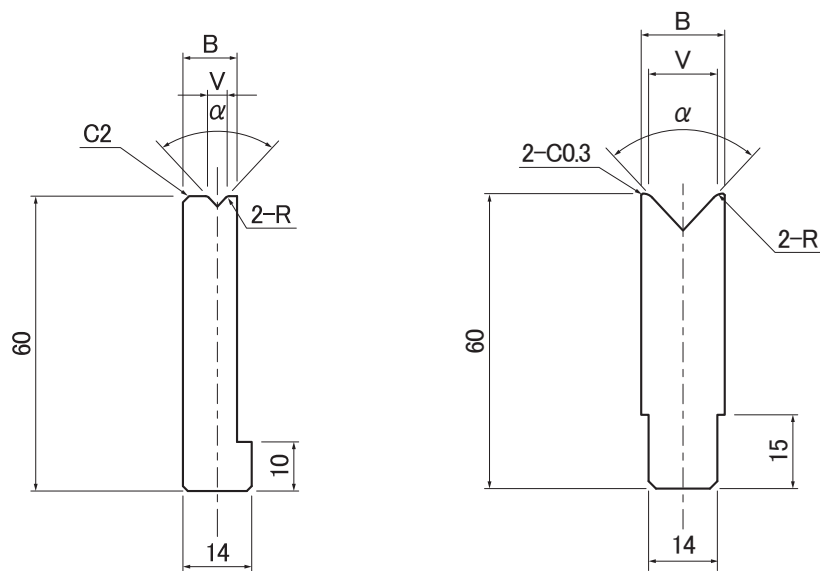
Material: **SCM440** Hardness: **HRC47 ± 3**  
 L: 835mm M: 510mm SS: 200mm  
 Sectioning A: 370mm B: 800mm Ears: 200mm

Series	V	$\alpha$	R	B	Max	Product No
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD	4	90	1.0	10.0	50	V004-90-S
	5			10.5		V005-90-S
	6		1.5	11.0	60	V006-90-S
	7			12.0	65	V007-90-S
	8			13.5	70	V008-90-S
	10		2.5	15.0	90	V010-90-S
	12			17.0	100	V012-90-S

\*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

\*It does not have special relief on the bottom V for standard.

Please contact us if you require.



STANDARD

# 30° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

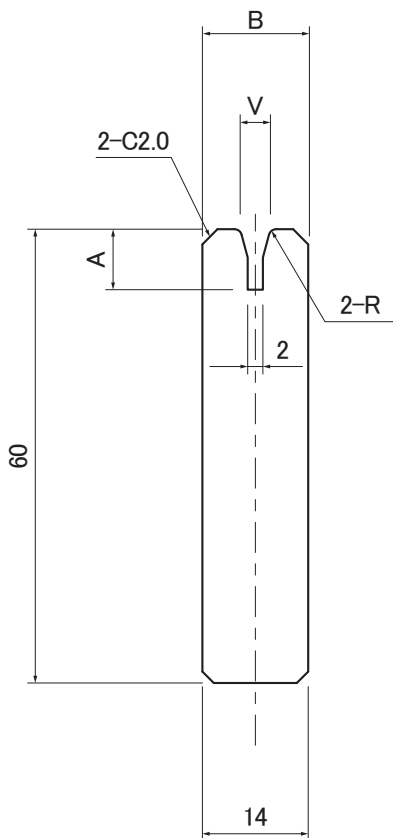
Sectioning A: 370mm B: 800mm Ears: 200mm

Series	V	$\alpha$	R	A	B	Max	Product No	
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)		
STANDARD	4	30	1.0	8.0	14.0	16	V004-30-S	
	6			11.5	17.0	18	V006-30-S	
	8		1.5	15.0	20.0	20	V008-30-S	
	10		2.0	20.0	25.0	26	V010-30-S	
	12		2.5	23.0	30.0	30	V012-30-S	
R-TYPE	4		30	1.5	8.0	14.0	16	V004-30-R
	6				11.5	17.0	18	V006-30-R
	8			2.5	15.0	20.0	20	V008-30-R
	10			3.0	20.0	25.0	26	V010-30-R
	12			4.0	23.0	30.0	30	V012-30-R

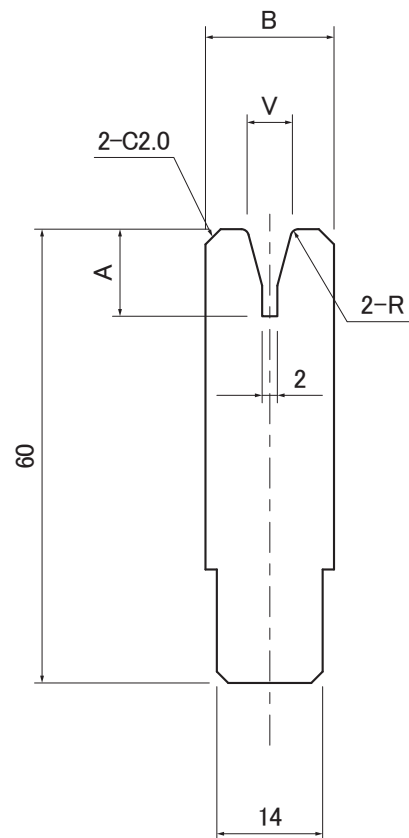
\*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

\*Special relief on the bottom V is standard.

Please contact us if you require.



STANDARD



R-TYPE

# BEND CHART

t : Material thickness

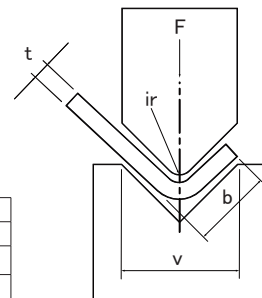
(Tensile Strength 450~500N/mm<sup>2</sup>)

F : Pressure per 1m (kN/m)

ir : Radius of punch tip

b : Minimum length of flange

v : Width of die



## For mild steel

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v	
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	b	
	ir																						
0.5	40	30																					
0.6	60	40	40	40																			
0.8		70	70	50	40																		
1		110	100	80	70	60																	
1.2			140	120	110	80	70	60															
1.4				150	130	110	100	90	80														
1.5				200	170	150	130	110	100	90													
1.6					170	150	130	110	100	90													
2						220	190	170	150	130	110												
2.3							250	230	190	170	150	120											
2.6								280	250	220	180	140											
3									340	300	240	190	150										
3.2										340	270	220	170	140									
3.5											330	260	200	160	130								
4												430	340	270	210	170							
4.5													440	340	270	210							
5														520	420	330	260	210					
6															600	480	380	300	240				
7																520	410	330	260				
9																	670	540	430				
10																		850	670	530	420		
12																			960	780	600	550	
16																				1360	1070	860	
19																					1500	1250	1000
20																					1700	1350	1080
22																						1600	1300
25																						2100	1700
30																							2400

F (kN)

## For stainless

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	b
	ir																					
0.5	60	50																				
0.6	90	60	60	60																		
0.7	120	80	80	60	60																	
0.8		110	110	80	70																	
0.9		130	120	100	90	70																
1		170	150	120	110	90																
1.2			210	180	150	120	110	90														
1.5				290	230	200	170	150	130	120												
2						330	290	260	230	200	170											
2.5									390	350	300	250	190									
3										510	450	360	290	230								
4											650	510	410	320	260							
5												780	630	500	390	320						
6													900	720	570	450	360					
8															1020	810	650	510				
10																1290	1010	800	630			
12																	1440	1170	900	830		
15																		1800	1410	1140		
20																			2500	2080	1670	
25																					3150	2550
30																						3600

F (kN)



## PRODUCT CATALOGUE

# AMADA TYPE

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## CONIC HIGH PERFORMANCE TOOLING

- AMADA TYPE TOOLING
- TRUMPF TYPE TOOLING
- MURATA TYPE TOOLING
- KOMATSU TYPE TOOLING
- TOYO TYPE TOOLING
- NISSHINBO TYPE TOOLING



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Dealer